

Date: Monday, 2/27/2006 4:18:55 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE KIT		
Job Number	: 25983		Part Number	: K10003		
Estimate Number	: 10532		Drawing Number	: K10003 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/27/2006	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/20/2006		
Previous Run	: 25854		Qty:	8	Um:	Each
Written By	<u>See Comment Below</u>					
Checked & Approved By	<u>KJ 06.02.28</u>					
Comment	: Est : 1 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :				
1.0	DC	DOCUMENT CONTROL				
		<span style="float: right;">DT 06/03/07</span>				
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile and type labels per PPP K10003CHG004 for D205-634-011 and D204-635-011						
2.0	D2570	Bushing				
<b>Comment:</b> Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s) Bushing Pick: Qty      Part Number      Description      Batch 24      D2570      Bushing <u>B25827</u> <u>B25827</u>						
3.0	D2571	Saddle, Fwd, Out				
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, Out Pick: Qty      Part Number      Description      Batch 1      D2571      Saddle <u>B25828x3, B25829x3, B25996x2</u>						
4.0	D2572	Saddle, Fwd, In				
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Fwd, In Pick: Qty      Part Number      Description      Batch 1      D2572      Saddle <u>B25997</u>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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5.0	D2573	Saddle, Aft, Out 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Aft, Out Pick: Qty Part Number Description Batch 1 D2573 Saddle B25998X5, B25861 X3 ✓
6.0	D2574	Saddle, Aft, In 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Saddle, Aft, In Pick: Qty Part Number Description Batch 1 D2574 Saddle B25999X5, B26363 X3 ✓
7.0	D27361	Lug Assembly 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Lug Assembly Pick: Qty Part Number Description Batch 1 D2736-1 Bracket B2418910 ✓
8.0	D27363	Lug Assembly 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Lug Assembly Pick: Qty Part Number Description Batch 1 D2736-3 Bracket B24375, ✓ 7my 1B26310
9.0	D2747	Set Screw 
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s) Set Screw Pick: Qty Part Number Description Batch 4 D2747 Socket Head Set Screw B24693 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: K10003

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B22182x14, B24851x2

11.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B22979x12, B24897x4

12.0 D2968041 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B24537

13.0 AN46A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	M19278

14.0 AN446A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	M19714

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 25983 Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	AN451A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	M18432 ✓

16.0	AN612A	Bolt
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M18079x6 / M100575 58 ✓

17.0	AN960JD416	Washer
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M19085 x6 / M100575 x250 ✓

18.0	AN960JD616	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M10035 ✓

19.0	AN9704	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	2XBN10534 6X M18918 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/04/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 MS21042L4 Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch  
29 MS21042L4 Nut (or MS21042-4) m19099 ✓

51 06.04.10

21.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

22.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Ref C Ref 4/4/10 (8)

23.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Ref 4/4/10 (8)  
Ref 6/6/10 (8)

Job Completion



U 06.04.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. K10003	REV. B SHEET 1 OF 1
DATE 00.11.22		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/ 212 /412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

\* REQUIRED WITH D2707-041 ONLY

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *25983*

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